

Date: Monday, 11/14/2008 2:30:26 PM
 User: Kim Johnston

Process Sheet

5

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY
 Job Number : 36719
 Estimate Number : 10022
 P.O. Number :
 This Issue : 1/14/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D205634011
 First Issue : 1/1 Type : LANDING GEAR Drawing Number : N/A
 Previous Run : 36718 Drawing Revision : N/A
 Material :
 Due Date : 1/31/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : AS 08 01 15
 Comment : Est Rev. 02.08.28 Removed QC5 from Step 5 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 08.01.22 (1)

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG005

AS 08/02/08 (1)

2.0 36719A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 36719A

AS 08/02/08 (X1)

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit 36308

AS 08/02/08 (X1)

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



(1)

Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/02/08

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: Rev J

SP AS 08/02/08 (X1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 28/10/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:30:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 36719

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/12

Job Completion



2008/2/12 ①

✓

36719A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:30:51 PM
User: Kim Johnston

Process Sheet

5

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 36719A		
Estimate Number	: 10023		
P.O. Number	:	Part Number	: D205634041
This Issue	: 1/14/2008 S.O. No. :	Drawing Number	: D2580 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 36718A	Material	:
Written By	:	Due Date	: 1/31/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 08 01 15</u>		
Comment	: Est Rev. N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev. O 06.02.28 Added paperwork EC Est Rev. P 07-07-09 SS Wearplates & Gaskets JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002

N/A

2.0	D25001190	Ext'n -I' Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2500-1-190	Skid Tube Extrusion	B29602
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a.m 08.01.15 ①

3.0	D2596	205 Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2596	205 Web	36803
---	-------	---------	-------

SL 8-1-17

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

a.m 08.01.15

①

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

a.m 08.01.15

①

3-Acid etch and Alodine tube per QSI 005 4.1

a.m 08.01.15

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:30:51 PM

User: Kjm Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36719A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 08-01-16

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

A.M 08.01.16 (1)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

A.M 08.01.16 (1)

3-Countersink holes as per Dwg D2580without cutting fluid

A.M 08.01.16 (1)

4-Deburr and blow out all chips from inside of tube

A.M 08.01.16 (1)

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

SL 8-1-17

Qty Part Number Description Batch

A/R Sikaflex-291 105469

Sikaflex expire date: 8-30-1

Start Time: 1:40 Date: 8-1-17

Fin Time: 1:15 Date: 8-1-21

7.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL/JR 8-1-21

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

A.M 08.01.22 (1)

2-Prepare tube for welding, remove alodine as required.

A.M 08.01.22 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:30:51 PM
User: Kjm Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36719A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08-01-28

10.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2576-3

Step

33321-1

BE 08-01-31

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

20

D2579

Spacers

336326

BE 08-01-28

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M106390 BE 08-01-31

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M106390 BE 08-01-28

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending a.m 08.01.29 ①

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur a.m 08.01.29 ①

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes a.m 08.01.29 ①

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur a.m 08.01.29 ①

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur a.m 08.01.29 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:30:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36719A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 0802-01 ①

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 0802-01 (X)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M.A

08/02/04

(1X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M106379

M.A

08/02/05

(1X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-02-05

①

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B 35663

BR

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M100188

BR

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M104885

BR 08-02-06

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36719A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS71032130

Insert



ALS 41032130

min 2008/2/11



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch:

M 105 729

BR

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch:

M 106 574

BR

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch:

M 107 008

BR

24.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 32714

BR

25.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 36526

BR

26.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch:

B 36934

BR

27.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B 36337

BR

BR 08-02-06 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:30:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36719A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B34805

BR

29.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B36637

BR

30.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B36338

BR

31.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B27168

BR

32.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B30327

BR

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 08-07

M105585

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

BR 08-02-06

BR 08-02-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/02/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:30:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36719A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

AVR Sikaflex-291

Sikaflex expire date:

M105585
08-07

BR

08-02-06

(1)

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M 106894

m-k

08/2/06

(11)

34.0

QC5

INSPECT WORK TO CURRENT STEP



08/2/07



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

36719

SP AS

08/02/08

(X)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/10

Job Completion



2008/2/11

(1)

W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36719A

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Diagram illustrating the grinding locations for the propeller cross-section. The diagram shows a cross-section of a propeller with the following labeled areas:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH

#0.208
DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241/-291

AN3-SA BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP

D2579 SPACER

WEB (REF)

.130 (REF)

0 PLACES

AFTER PERFO

1. CHA

2. INS

3. WE

4. C'B





AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT 02579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE 02579 SPACER TO Ø0.437 X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2596 WEB
3 7
1.750 1.750
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

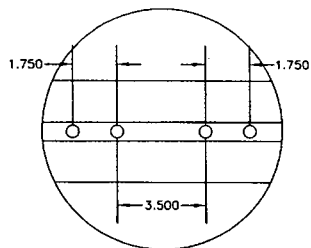
0.5
 1.5
 1.5
 D
 P P P P P P P
 D
 8
 1.5
 1.5
 1.5
 WELD AS PER DETAIL B
 BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE
 BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE
 REFER TO DETAIL C
 D3566-1
 D3566-5
 D3566-1
 D3566-13
 D3564-11
 D3564-5
 D3564-9
 D3564-13
 AN304A BOLT (1)
 AN960C10L WASHER (1)
 (50 PLACES)

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

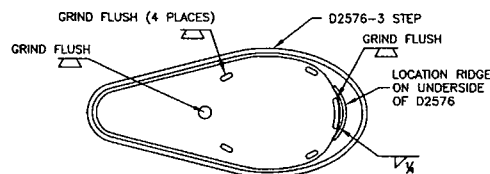
DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE			
07.02.27			

DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

DETAIL E
SCALE 5:24

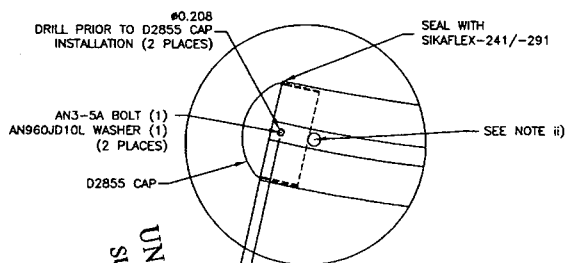


DETAIL F
SCALE 5:24

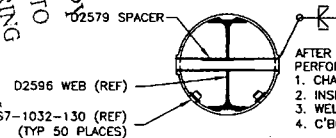


RELEASED
07 Dec 88

DETAIL G
SCALE 5:24

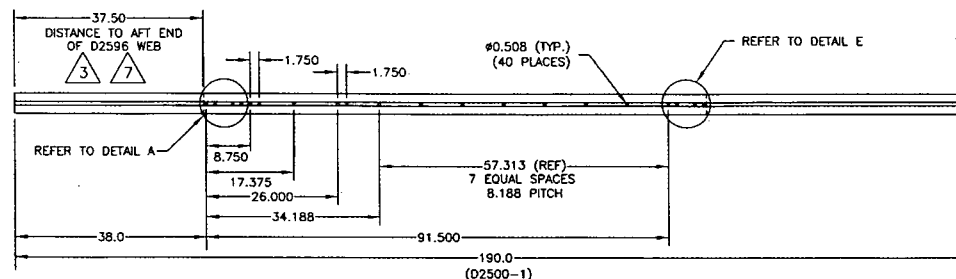


SECTION H-H
SCALE 5:24

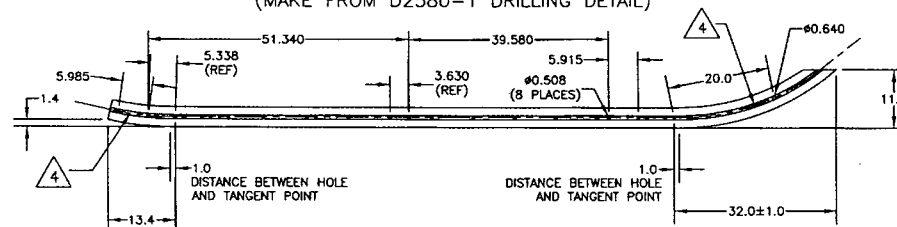


- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

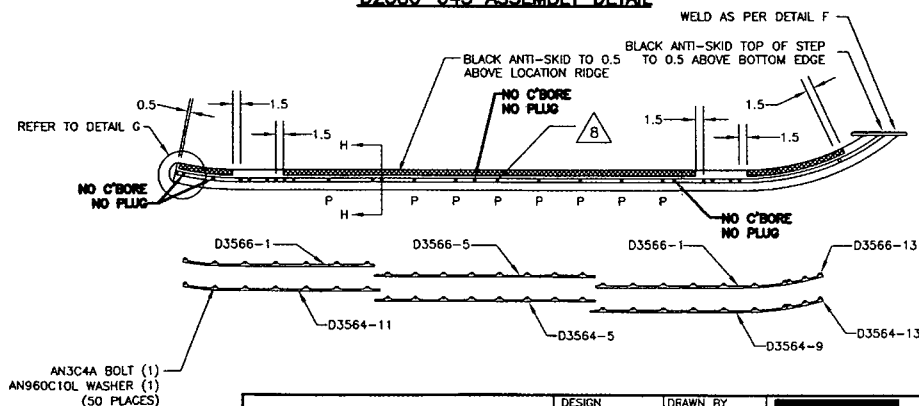
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



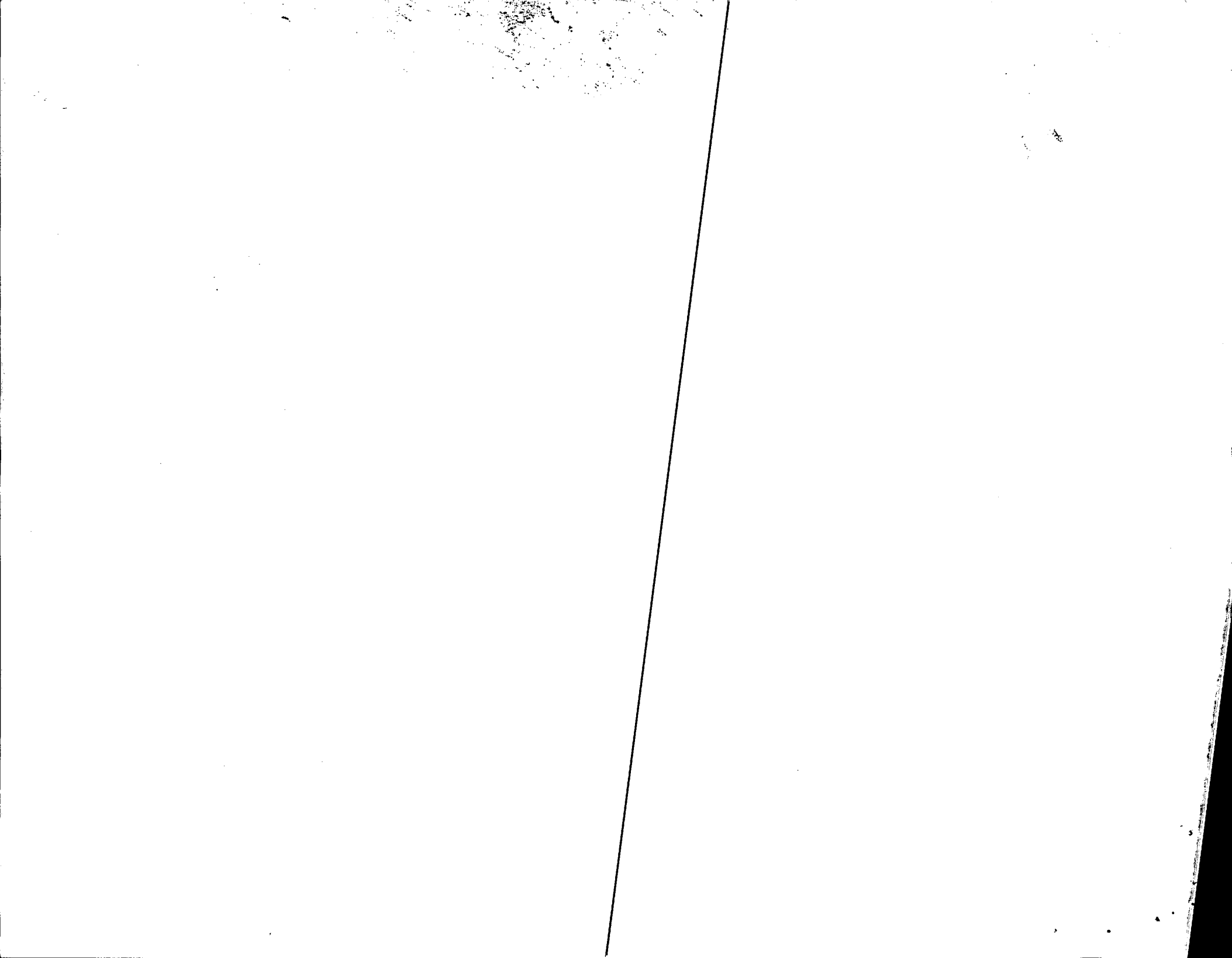
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED <i>RH</i>	APPROVED <i>RH</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	



NO. 141

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Borley E
Joint Welding Procedure GTAW
Part number and Job number D 205 64 01 / B367214

TEST WELDS REQUIRED

BASE METAL Aluminum
Penetration Complete ☐ Partial ☒
Current AC ☒ DC ☐

WELDING PROCESS Tig
Single Weld ☒ Double Weld ☐
Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 020201 Qualifier Pat Neal